Work Order ID 53825 -2

Split 2

Beanpaw

November 19, 2009 8:37:25 AM

Item ID: D4013-041 **Accept** **Setup Start**

Revision ID:

Item Name: Wearplate Assembly 14. **Stop**

Start Date: 11/19/2009 **Start Qty:** 18.00

Required Date: 11/23/2009 **Req'd Qty:** 18.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MF **Date:** 09-11-19 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4013	C								
100		0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4013-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									

PD ⇒

IB 9-11-19

IB 9-11-19

Dart Aerospace Ltd

W/O: 53825		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/11/19	# 120	Took Qty x1 For QC Template	S	09/11/19	x1		S 09/11/19

Part No: D4013-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53825

November 19, 2009 8:37:25 AM

Item ID: D4013-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/19/2009 **Start Qty:** 18.00 **Cust Item ID:**

Required Date: 11/23/2009 **Req'd Qty:** 18.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(19)	Took qty For Template		
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				19	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(19)	0		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53825

November 19, 2009 8:37:25 AM

Item ID: D4013-041 **Accept** **Setup Start**

Revision ID:

Item Name: Wearplate Assembly **Stop**

Start Date: 11/19/2009 **Start Qty:** 18.00 **Cust Item ID:**

Required Date: 11/23/2009 **Req'd Qty:** 18.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Large Fab	**Memo**	0.00							
Large Fab	1- Weld cup, stud as per dwg use DT9550 A/R S.S. ROD BATCH: M108160 2- Apply hardfacing on wearplate and on studs (studs only 5 places not the cups) as indicated on dwg A/R HARDCOAT 2059B BATCH: M117963								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									

EL 9-11-26 (X15)

2) 8 oz lube

~~09/11/26~~ (X5) JC

JC 09/11/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53825

November 19, 2009 8:37:25 AM

Item ID: D4013-041 **Accept** **Setup Start**

Revision ID:

Item Name: Wearplate Assembly **Stop**

Start Date: 11/19/2009 **Start Qty:** 18.00 **Cust Item ID:**

Required Date: 11/23/2009 **Req'd Qty:** 18.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M1090911	0.00							
	Memo ✓ ***MASK THREADS AND HEXAGONAL OPENING PRIOR TO PAINTING***	0.00							
190 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
200 Packaging Packaging	Identify as per dwg & Stock Location: THERMO	0.00							
	Memo w/o 53825	0.00							

ML 09/11/26
START : 1200pm
TEMP 320°F
FIN 12:30pm
(X15) 9

BR 09-11-26
(15)

(15)
BB 09/11/26.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 53825

November 19, 2009 8:37:25 AM

Item ID: D4013-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/19/2009 **Start Qty:** 18.00 **Cust Item ID:**

Required Date: 11/23/2009 **Req'd Qty:** 18.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

09/11/26 AJ

4 09-11-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 19, 2009 8:37:25 AM

Work Order ID: 53825

Parent Item: D4013-041

Parent Item Name: Wearplate Assembly

Start Date: 11/19/2009 **Required Date:** 11/23/2009

Start Qty: 18.00 **Required Qty:** 18.00

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
RevB prelim per ECN09-698p 09.11.02 DD verified by:EC
redesign 09.11.12 DD verified by:EC
IPP RevB:
IPP RevC:
IPP RevD: revC as per

M304S16GA	Purchased	No	100	sf	190.6742	18.3789

304/316 Sheet .063

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	190.6741737	
106860	16.018	
111924	25.1689737	
112442	29.8899	
112567	0.2973	
112885	119.3	

D4013-3	Manufactured	No	150	Each	20.0000	54.0000

Stud

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	20	
53183	20	

D4013-5	Manufactured	No	150	Each	0.0000	108.0000

Cup

D4013-9	Manufactured	No	150	Each	0.0000	36.0000

Stud

D4013-11	Manufactured	No	150	Each	0.0000	36.0000

Stud

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53825
Description: WEARPLATE ASSEMBLY	Part Number:	D4013-041
Inspection Dwg: D4013-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

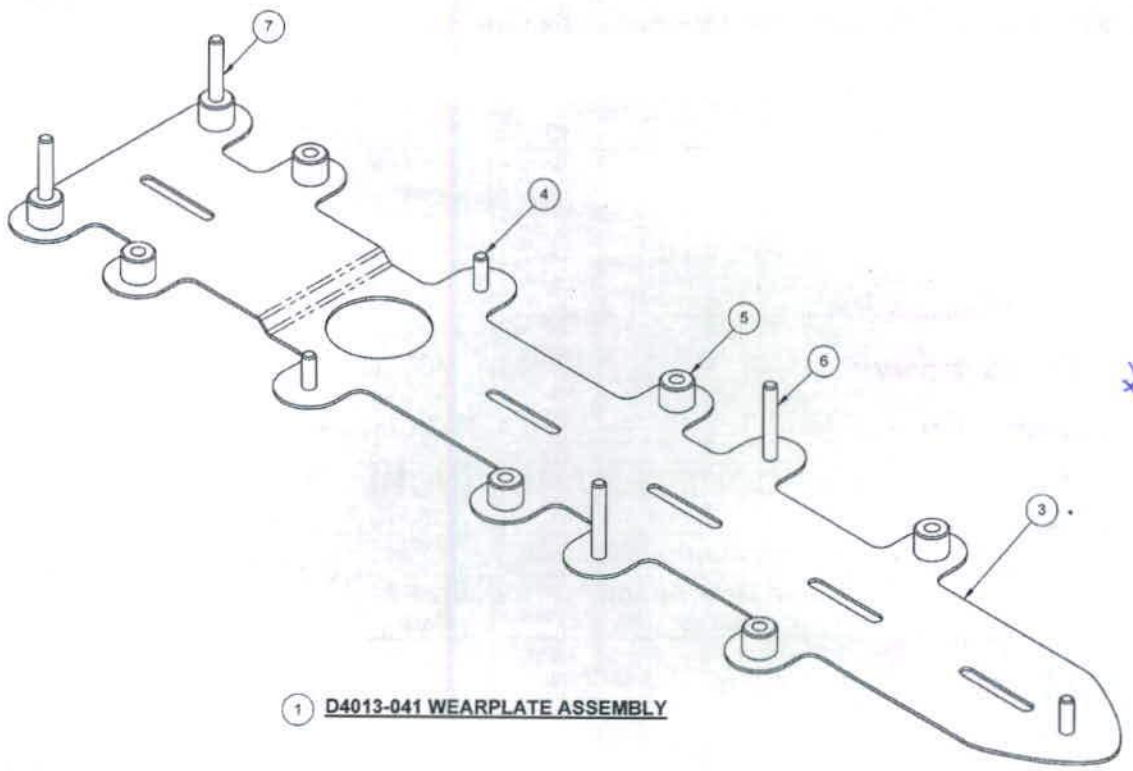
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .250	+.005 -.001	.251	X			
Ø .625	+.008 -.001	.627	X			
Ø 1.88	+~~.003~~ -~~.001~~	1.873	X			+/- 0.030 09.11.19
.625	+/- .010	.623	X			MAKE PERMANENT CHG.
2.938	+/- .010	2.933	X			
6.876	+/- .010	6.875	X			
7.271	+/- .010	7.272	X			
12.146	+/- .010	12.146	X			
14.458	+/- .010	14.458	X			
18.458	+/- .010	18.458	X			
23.958	+/- .010	23.958	X			
25.04	+/- .030	25.04	X			
.250	+/- .010	.248	X			
1.750	+/- .010	1.751	X			
1.50	+/- .030	1.503	X			
2.125	+/- .010	2.125	X			
2.75	+/- .030	2.751	X			
.063	+/- .010	.058	X			

Measured by:	IB
Date:	9-11-19

Audited by:	
Date:	07/4/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



(1) **D4013-041 WEARPLATE ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

53825

PRELIMINARY ISSUE

REV.	DESCRIPTION	BY	DATE
C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5; ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDTEX	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.11.11	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

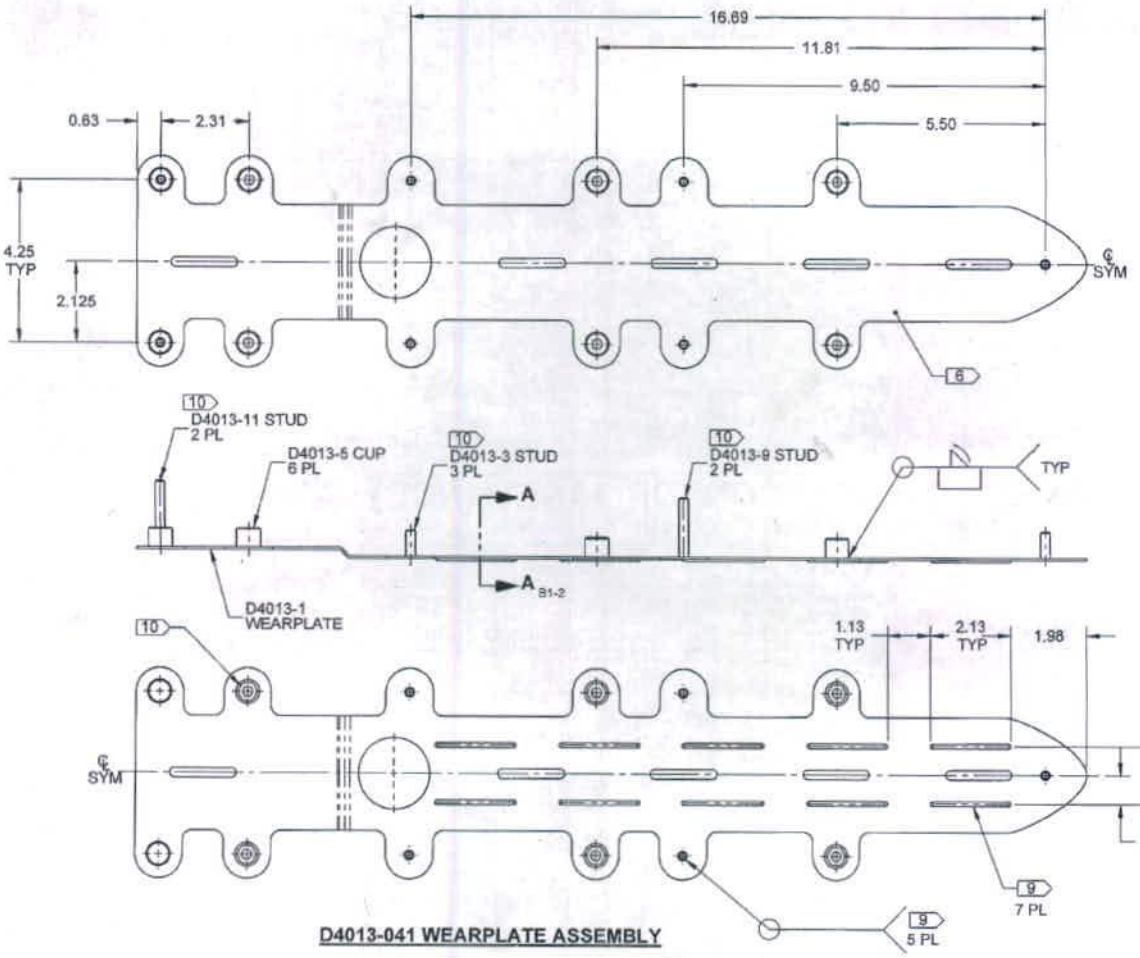
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

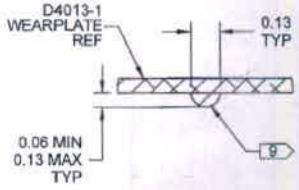
#S3635

PRELIMINARY ISSUE

C



D4013-041 WEARPLATE ASSEMBLY



SECTION A-A B6-2
SCALE 6X

NOTES:
1) MATERIAL: SEE SHEETS 3 AND 4
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3 C
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.89 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 10 PL
10) MASK THREADS (7 PL) AND HEXAGONAL OPENINGS (6 PL) PRIOR TO PAINTING

DESIGN	LB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	LB	
CHECKED	FJS	DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.11.11	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

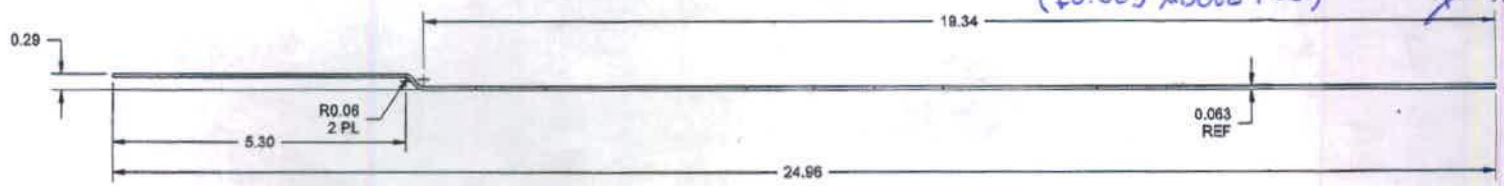
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

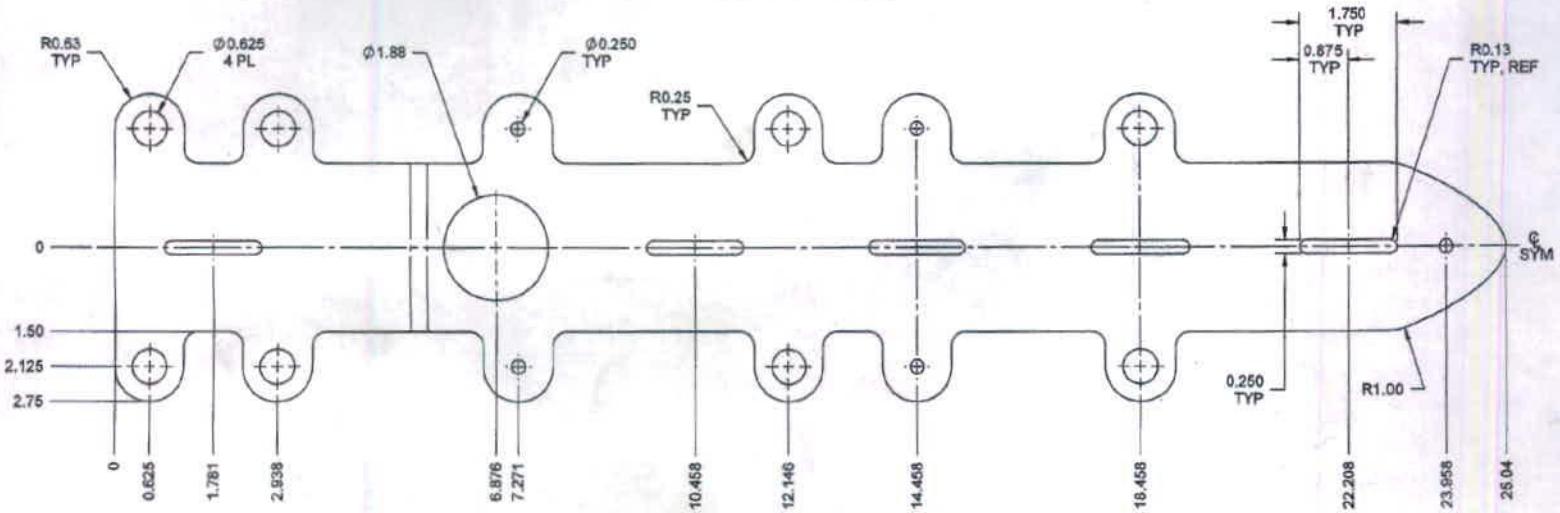
NOTE: Date & initial all entries

PRELIMINARY ISSUE

19.375 MAX IS ACCEPTABLE. (+0.005 ABOVE TOL.) 09.11.20



D4013-1 WEARPLATE
(MAKE FROM D4013-1F)

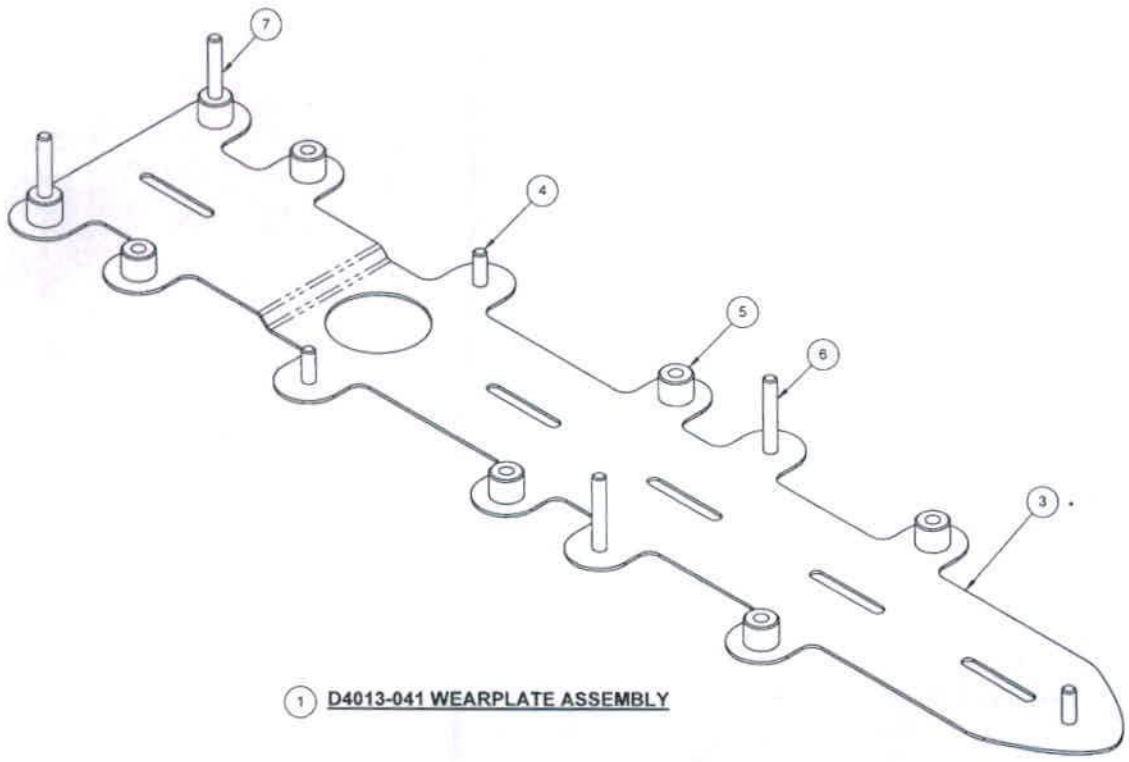


D4013-1F WEARPLATE FLAT PATTERN

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.48 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.11.11		

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1 **D4013-041 WEARPLATE ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

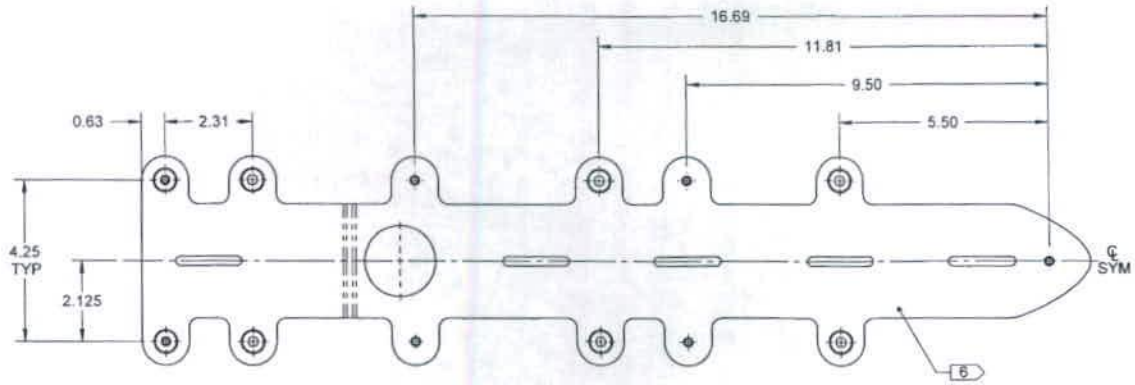
53825

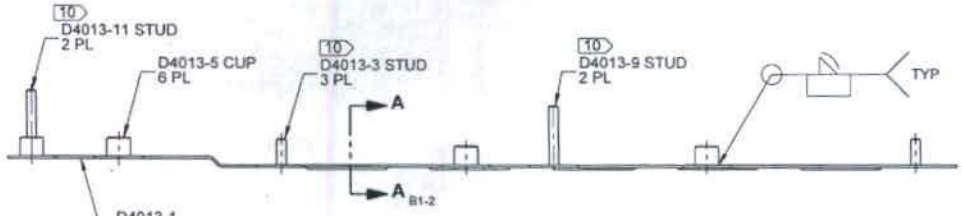
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2009 -11 24

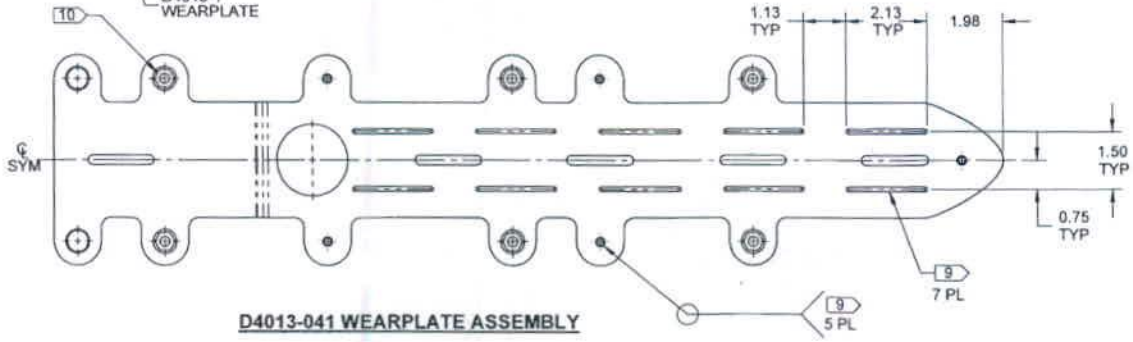
REV.	DESCRIPTION	BY	DATE
C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5. ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDTEX	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22

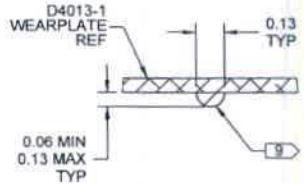
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.11.11		

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SECTION A-A B6-2
SCALE 6X

D4013-041 WEARPLATE ASSEMBLY

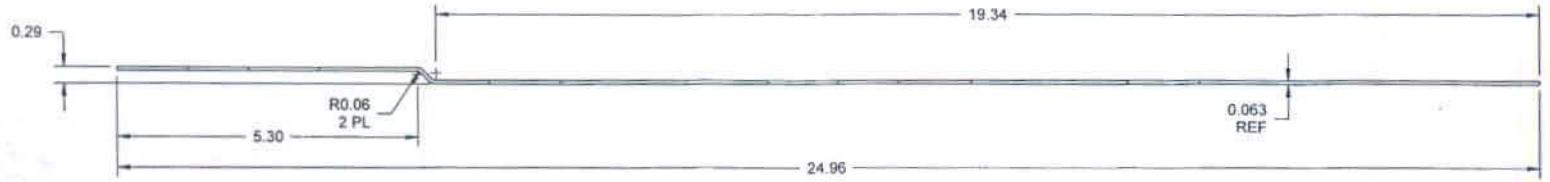
I3825

RELEASED
2009 -11- 24

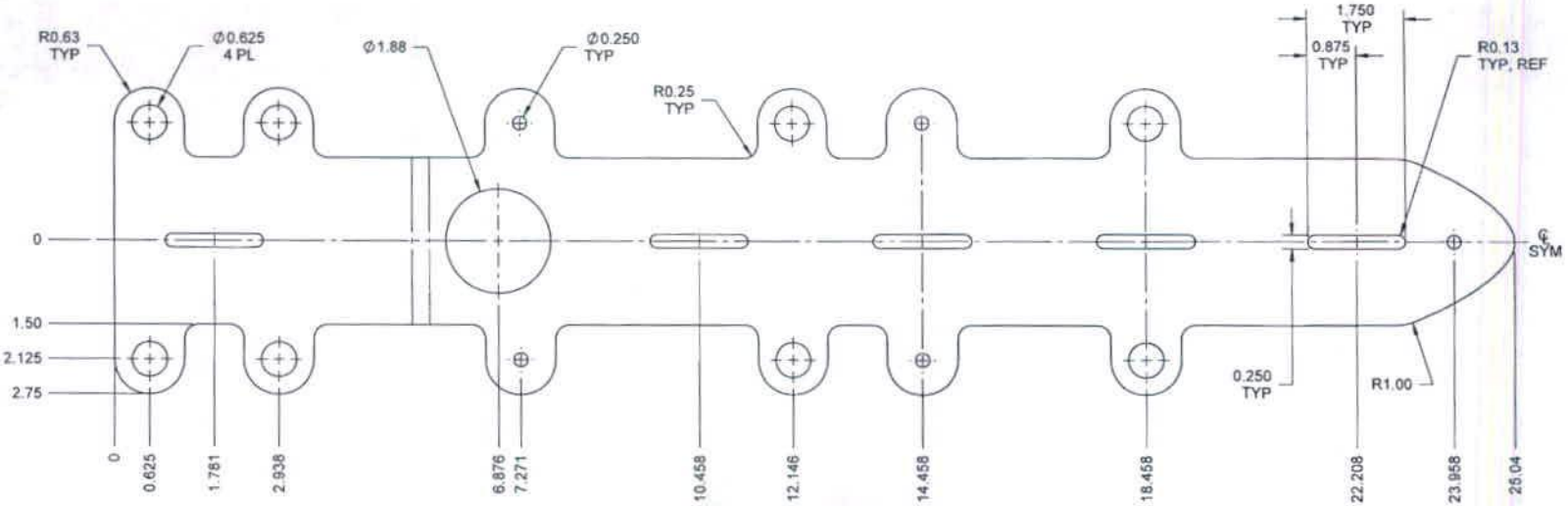
NOTES:
1) MATERIAL: SEE SHEETS 3 AND 4
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3 (C)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.89 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 10 PL
10) MASK THREADS (7 PL) AND HEXAGONAL OPENINGS (6 PL) PRIOR TO PAINTING

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	F.J.S	DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.11.11	

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D4013-1 WEARPLATE
(MAKE FROM D4013-1F)



D4013-1F WEARPLATE FLAT PATTERN

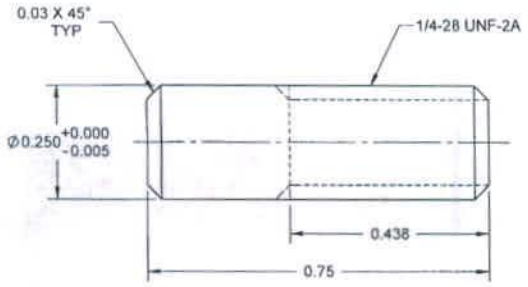
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2009 -11- 24

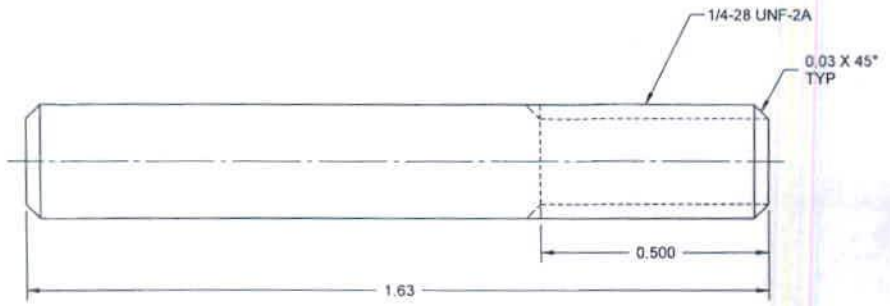
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.48 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	RJS	DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.11.11	

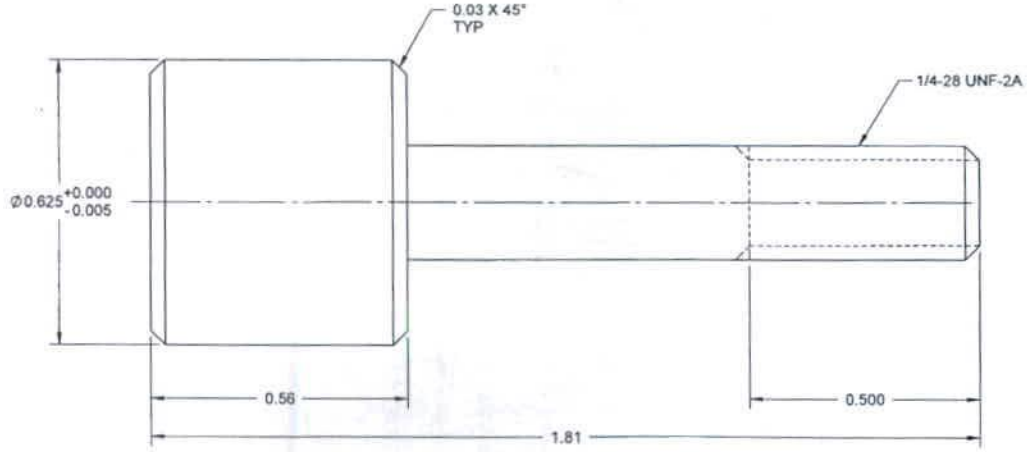
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D4013-3 STUD



D4013-9 STUD



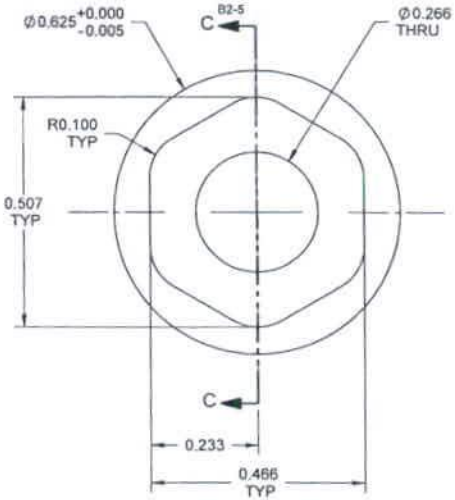
D4013-11 STUD

RELEASED
2009 -11- 24
53825

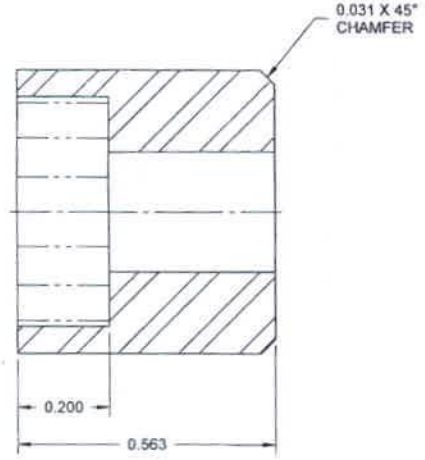
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: LESS THAN 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4013 — REV. C
CHECKED	AJS	SHEET 4 OF 5
MFG. APPR.	DD	TITLE — SCALE
APPROVED		WEARPLATE ASSEMBLY — NTS
DE APPR.		
DATE	09.11.11	

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△C **D4013-5 CUP**



SECTION C-C D6-5

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NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4013 REV. C
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.11.11		

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